Qty:

Tuesday, 4/4/2006 1:27:38 PM

- User

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 26500 **Estimate Number**

: 10822

P.O. Number

: N/A

This Issue

: 4/4/2006

: NIA : 26078

: NC

S.O. No. : N/A

: MACHINED PARTS Type

Part Number **Drawing Number**

Due Date

Drawing Name

: D2274 : D2274 REV F : N/A

: RADIUS BLOCK

Project Number Drawing Revision

Material

: 4/20/2006

500 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

Added inspection level 8

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6B0750X00125



6061-T6 Bar .75" x .125"

Comment: Qty.: 0.0962 f(s)/Unit

Total: 48.0900 f(s)

6061-T6 Bar .75" x .125"

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch M 100682 SHEAR

2.0

Comment: SHEAR

Shear blanks 9.00" long +/- 0.030"

Note: 1 blank makes 9 pieces

HAAS CNC VERTICAL MACHINING #1

06/04/30

3.0

HAAS1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2274

06/05/01 520

520

520

520

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK

06/05/01

5.0

Comment: SECOND CHECK

06/05/01

Dart Aerospace Ltd	С)a	ı	t	A	er	Ó	S	p	a	C	е	L	.to	t	-
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W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	By Date Qty Approval Chief Eng / Prod Mgr QC Inspect										
	ŧ												
Part No	:	PAR #: Fault Category:	NCR: Yes (No) DQA Date: Clerkis Co										

Part No:		PAR #:	_ NCR: Yes (DQA:	Date: <u>⟨</u>	yolad cyl	
				QA: N/0	Closed:	Date: _	
NCR:			WORK ORDER NON-CONFORMA	ANCE (NCR)			
DATE		Description of NC	Corrective Action Section	on B	Verification	Annroval	Approval
DATE STEP			Initial Astian Description	Cian 9 VEIIIICALIOII /		Approvai	Approval

NOIK.								
		Description of NC		Corrective Action Section B		Verification	Ammaral	Ammoust
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Tuesday, 4/4/2006 1:27:38 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: RADIUS BLOCK Customer: CU-DAR001 Dart Helicopters Services Job Number: 26500 Part Number: D2274 Job Number: Seq. #: **Machine Or Operation:** Description: SMALL FAB 1 6.0 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble 06/05/01 Deburr any rough edges after tumbling 520 HAND FINISHING HAND FINISHING RESOURCE #1 7.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 06-05-02 520 INSPECT WORK TO CURRENT STEP 8.0 Comment: INSPECT WORK TO CURRENT STEP 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock A 06/05/03 518 Location: ST35 10.0 DC DOCUMENT CONTROL Comment: DOCUMENT CONTROL D 06/05/04 U Olers 5-04 Inspection Level 21 Job Completion Z,

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W/O:		WORK ORDER CH						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No		PAR #: Fault Category:	NCR: Yes	No DO	۸.	Date:	L	

QA: N/C Closed: ____ Date: __

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Annroyal	Approval				
DATE	STEP	Section A	Initial Chief Eng				Approval Chief Eng	QC Inspector			
 											
							0				
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26500
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	.259				
0.750	+/-0.010	752				
0.375	+/-0.010	.374	/			
0.125	+/-0.010	.129	/			
0.750	+/-0.010	748				
0.063	+/-0.010	058	/			
				·		

Measured by: ブル	Audited by:	5	Prototype Approval:	
Date: 06/04/30	Date:	06/04/32	Date:	

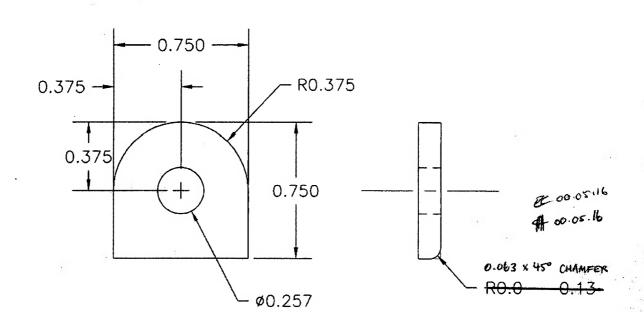
Rev	Date	Change	Revised by	Approved
Α	03.10.07	New Issue	KJ/RF	





	DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
	CHEC	(ED/	APPROVED	DRAWING NO.	REV. F			
		N DI	4	D2274 SHEET	1 OF 1			
	98.08.11			TILE	SCALE			
			-	RADIUS BLOCK	2:1			
	Α		94.09.29	NEW ISSUE				
	C		95.07.12	RADIUS ENDS				
	۵		97.03.24	ADD MATERIAL SPECIFICATION				
	E		97.12.12	ADD FINISH & TOLERANCE QSI				
	F		98.08.11	RO.0 - 0.13 WAS RO.063 - 0.125	5			





SHOP COPY

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ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK

OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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